Dart Aerospace Ltd. Friday, 5/25/2007 12:39:59 PM Kim Johnston User: **Process Sheet** : SPACER **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 11167 **Estimate Number** : D32783 Part Number : NA P.O. Number S.O. No. : NA · D3278 REV B **Drawing Number** : 5/25/2007 This Issue : N/A Project Number : NC Prsht Rev. : SMALL /MED FAB : B **Drawing Revision** First Issue ALL: : 31941 Material Previous Run Qty: : 6/1/2007 Due Date 40 Um: Written By Checked & Approved By New issue KJ/JLM Comment : Est. A 04.04.19 **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: MDELRINS0125X300 Black Delrin 1.0 Comment: Qty.: 1.4448 sf(s) 0.0361 sf(s)/Unit Total: Black Delrin Use DT8685 Router Table. Material: Black Delrin/UHMW 0.125" thick (M-DELRIN-S0.125x30.0) Identify for D3278-3 07/06/05 Batch: 115607 FLOW WATER JET 20 Comment: FLOW WATER JET 1-Cut as per Dwg D3278 Dwg Rev:___ Prog Rev:_ 07/06/08

2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

UADO

106/06 41

Each

41

4.0 QC8

3.0

QC2

Comment: SECOND CHECK

SECOND CHECK



Page 1

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W/O:		WORK ORDER CHANGES	;				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
			-				
Part No		PAR #: Fault Category: I	NCR: Ye	s No DQ	A:	Date: _	

Date: _

QA: N/C Closed: ____

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	A
DATE	STEP	Section A	Initial Chief-Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector
07/06/06	Z, U	machine 4 part scrap		Scraps - destry/replan	SAN			
0 11 1		machine malfunction.	1	(41) now on W/O	07/06/06			1
		machine malfunction. holes to large, eve to get offset.	asious			0706.06	DQ\$1042	107060
İ								

NOTE: Date & initial all entries

	ay, 5/25/2007 12:40:00 PM Johnston	Process Sheet
Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: SPACER
Job Number:	32692	Part Number: D32783
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comme	ent: SMALL & MEDIUM FAB RESOURCE 1 1-C'sink as per dwg D3278 2-Deburr	*Notes c'sink on the wider side X4)
6.0	QC5	INSPECT WORK TO CURRENT STEP
	ent: INSPECT WORK TO CURRENT STEP	PACKAGING RESOURCE #1
7.0	PACKAGING 1	
Comme	ent: PACKAGING RESOURCE #1 Identify and Stock Location: <u>G A</u>	Store X 12 /07/6/11
8.0	QC21	FINAL INSPECTION/W/O RELEASE
Comme	ent: FINAL INSPECTION/W/O RELEASE	
Job Completion		U 87.06.12

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W/O:		WORK ORDER CH	IANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No):	PAR #: Fault Category:	NCR: Yes	No DQ	A :	Date:	

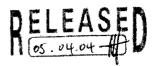
QA: N/C Closed: ____ Date: ___

NCR:		W	ORK OR	DER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Approval Chief Eng	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector
07/96/11	7	Scraponi part when intall riset	ESIOLZ	Scrap and not replace	07/06/11	107-06-12	by min	Kr. 46.0
			1031041			107-06-12	rusicur	
							:	

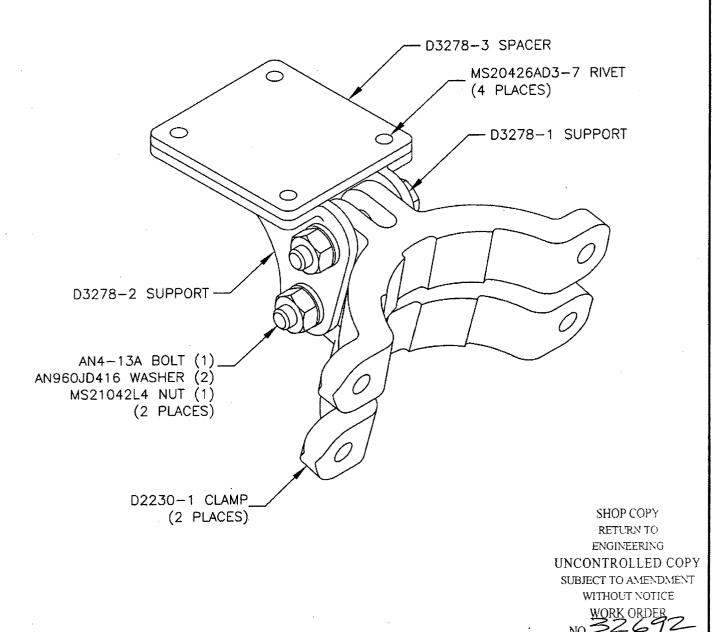
NOTE: Date & initial all entries



	DESIG	CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA)
1	CHECK	(ED ,,)	APPROVED	DRAWING NO.	REV. B
		做	#	D3278 SHEE	T 1 OF 3
	DATE			TITLE	SCALE
	05.0	3.31		SUPPORT ASSEMBLY	NTS
	Α		04.03.03	NEW ISSUE	
	R		05.03.31	CHANGE DIM/TOL TO ENSURE FIT	



D3278-041 SUPPORT ASSEMBLY

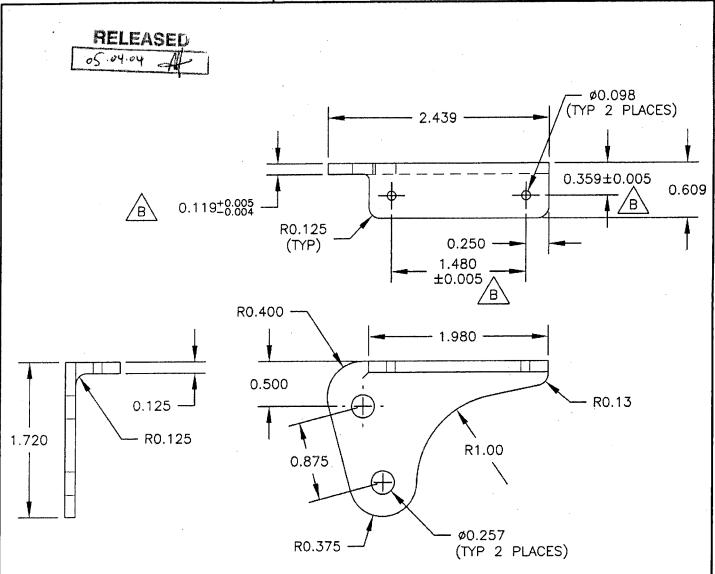


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#	#	D3278	SHEET 2 OF 3
DATE	1	TITLE	SCALE
05.03.31		SUPPORT ASSEMBLY	1:1



D3278-1 SUPPORT (SHOWN)

D3278-2 SUPPORT (OPPOSITE)

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/8 OR QQ-A-250/11) (REF DART SPEC. M6061T6B OR M6061T6S) SHOP COPY
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

RETURN TO

ENGINEERING

UNCONTROLLED COPY SUBJECT TO AMENDMENT

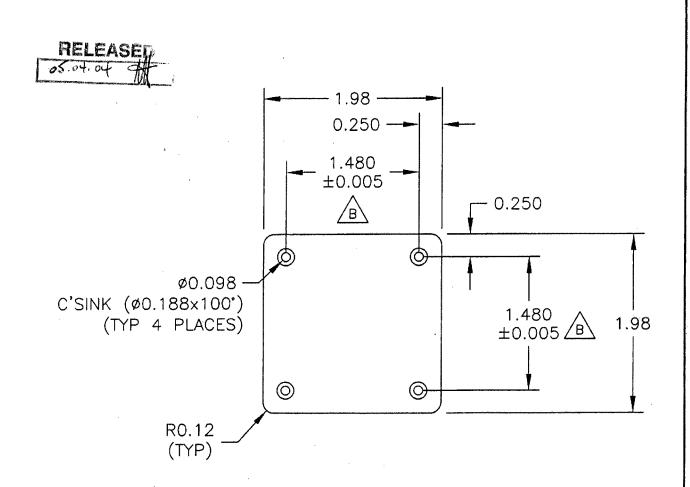
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CHECKED	APPROVED A	DRAWING NO.	REV. B
#	世	D3278	SHEET 3 OF 3
DATE		TITLE	SCALE
05.03.31		SUPPORT ASSEMBLY	1:1



D3278-3 SPACER

SHOP COPY RETURN TO

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR MNODEERIN-S 0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

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WORK GRDER

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DART AEROSPACE LTD	Work Order:	32692
Description: Spacer	Part Number:	D3278-3
Inspection Dwg: D3278 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.98	+/-0.030	1.99	/		Vern	
1.98	+/-0.030	1.99 *	/		Jein	
1.480	+/-0.005	1.482	/		Vern	
0.250	+/-0.010	0.755	~		Vern	
1.480	+/-0.005	1.482.			Vern	
0.250	+/-0.010	0,256	/		Very	
Ø0.098	+0.005/-0.000	Ø0.100 .	/		Vern	
R0.12	+/-0.030	RO.12			Vern	
0.125	+/-0.010	0.124	/		Vern	

Measured by: SAN	Audited by:	Prototype Approval:	N/A
Date: 07/06/06	Date: 07.06.07	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.04.19	New Issue P/O D3278-041	KJ/JLM	
В	06.03.09	Dwg Rev updated	KJ/JLM	
С	07.02.02	Dwg updated per JLM	KJ/JLM	